

Date: Tuesday, 11/6/2007 1:13:29 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEM
Job Number : 35546	
Estimate Number : 10857	
P.O. Number : <u>N/A</u>	Part Number : D34073
This Issue : 11/6/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3407 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 34648	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 11/26/2007
Checked & Approved By : <u>[Signature] 07/11/07</u>	Qty: <u>40</u> Um: Each
Comment : Est Rev: 05.10.18 New issue KJ/EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174R0750	Inventory
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Comment: Qty.: 0.3843 f(s)/Unit Total : 7.6860 f(s)  
 Material: 17-4ph SS Round Bar Ø0.750(M17-4-R0.750)  
 Identify for D3407-3  
 Batch: 111P5710 RD 07/11/14

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA597 Rev: C & Dwg D3407 Rev: C

2-Deburr

DISP 07/11/15 42

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA597 and Dwg D3407

2-Deburr

SL 07/11/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 21/1/26  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/6/2007 1:13:29 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 35546

Part Number: D34073

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 07/11/23

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S.F 07/11/23

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PAT Dural

JS

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(42)

Comment: FINAL INSPECTION/W/O RELEASE

07/11/26

Job Completion



W 07.11.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35546
Description: Stem		Part Number:	D3407-3
Inspection Dwg: D3407	Rev: C	Page 1 of 1	

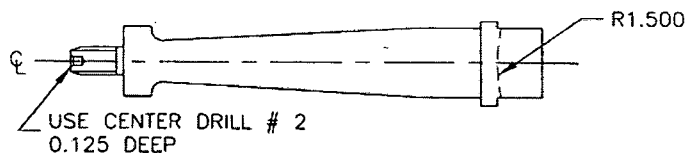
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.325	+/-0.010	4.320	✓			
3.305	+0.000/-0.010	3.299	✓			
2.555	+/-0.010	2.547	✓			
0.250	+/-0.010	.256	✓			
0.063	+/-0.010	.063	✓			
0.470	+/-0.010	.468	✓			
0.500	+/-0.010	.500	✓			
0.550	+/-0.010	.548	✓			
Ø0.625	+/-0.010	.621	✓			
Ø0.750	+/-0.010	.746	✓			
Ø0.363	+/-0.010	.363	✓			
0.250	+0.010/-0.000	.251	✓			
0.625	+/-0.010	.626	✓			
0.150	+/-0.010	.153	✓			
R0.125	+0.010/-0.000	r.125	✓			
1/4-28 UNF	N/A	2A	✓			

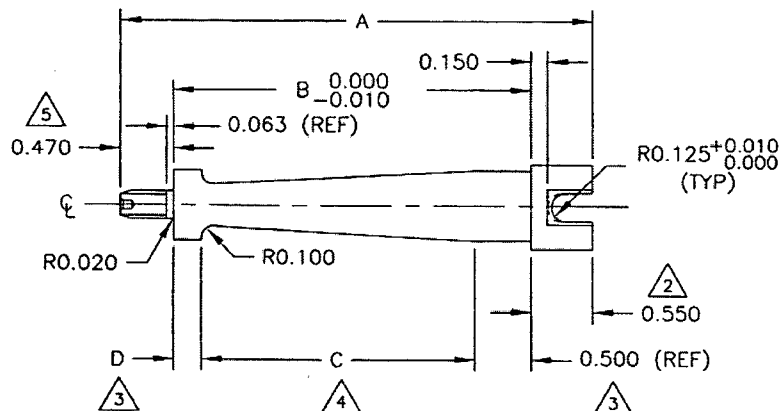
Measured by: <u>ND / S.L.</u>	Audited by: _____	Prototype Approval:	N/A
Date: <u>07/11/14/07/11/22</u>	Date: _____	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM	
B	07.09.26	Tolerances revised	KJ/EC	<u>BE</u>



RELEASED

05 09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

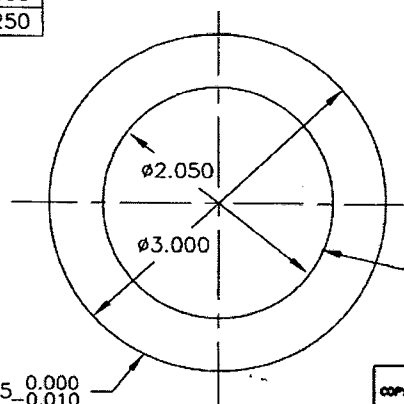
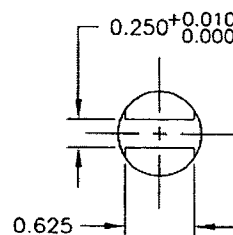
### D3407-1/-3 STEM

### D3407-1 AND D3407-3 STEM:

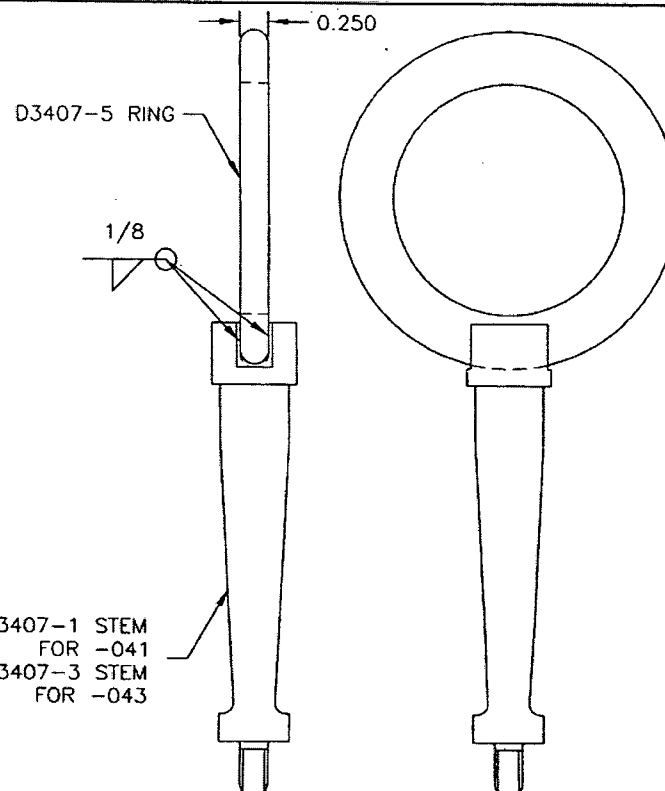
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2)  $\phi 0.750$  O.D.
- 3)  $\phi 0.625$  O.D.
- 4) MACHINE UNIFORM TAPER FROM  $\phi 0.363$  O.D. TO  $\phi 0.625$  O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

### D3407-5 RING:

- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



### D3407-5 RING



USE D3407-1 STEM FOR -041  
USE D3407-3 STEM FOR -043

### D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	HA	APPROVED HA
DATE	05.09.09	TOW RING
DRAWING NO.	D3407	REV. 2
TITLE	TOW RING	SHEET 1 OF 1
SCALE	1:1	

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35546